

Date: Thursday, 9/14/2006 7:28:42 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : VALVE SEAL
Job Number : 28558	
Estimate Number : 12207	
P.O. Number : <i>N/A</i>	Part Number : D34707
This Issue : 9/14/2006 S.O. No. : <i>N/A</i>	Drawing Number : D3470 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 26988	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 10/6/2006 Qty: 4 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev: A New Issue 06-04.20 EC	

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 ~~MSIL603125~~ *MSIL605063* high temp. silicone sheet .125



*D3255 gasket*



Comment: Qty.: 0.0648 sf(s)/Unit Total: 0.2591 sf(s)

Material: *.125" Thick High Temp Silicone sheet*

*(MSIL603125) (MSIL605063) B26473*

Batch: *[Signature]*

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

Cut as per Dwg D

Dwg Rev: *A*

Prog Rev: *A*

*[Signature] 06/10/02*

*(4)*

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*[Signature] 06/10/02*

*(4)*

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*[Signature] 06-10-03 (4)*

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5441*

*[Signature] 06/10/03*

*(4)*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: LD Date: 06/10/05  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/14/2006 7:28:42 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VALVE SEAL

Job Number: 28558

Part Number: D34707

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

09/10/05

Job Completion



U 86-10-05

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

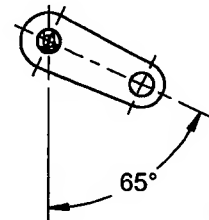
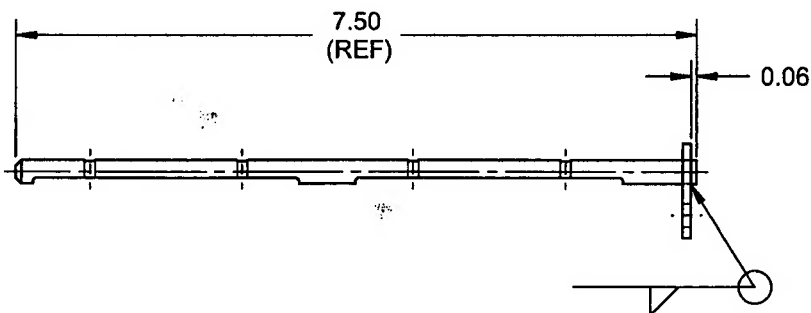
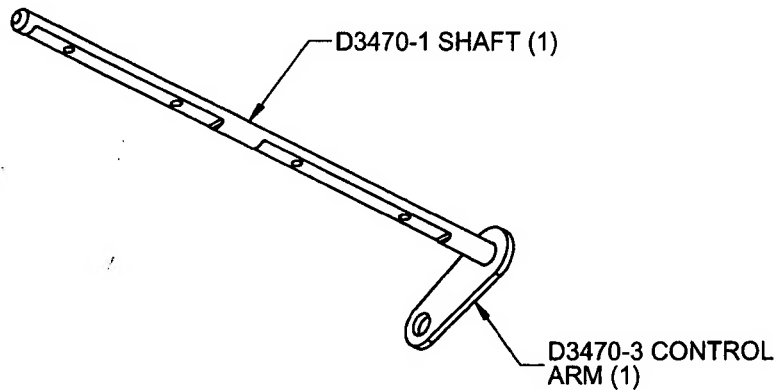
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3470</b>	REV. A SHEET 1 OF 4
DATE- <b>05.12.14</b>		TITLE <b>SHUT-OFF VALVE SHAFT</b>	SCALE 1:2
A	05.12.14	NEW ISSUE	

**D3470-041 SHUT-OFF VALVE SHAFT**SHOP COPY  
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06.04.03 SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER

NO. 28558

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

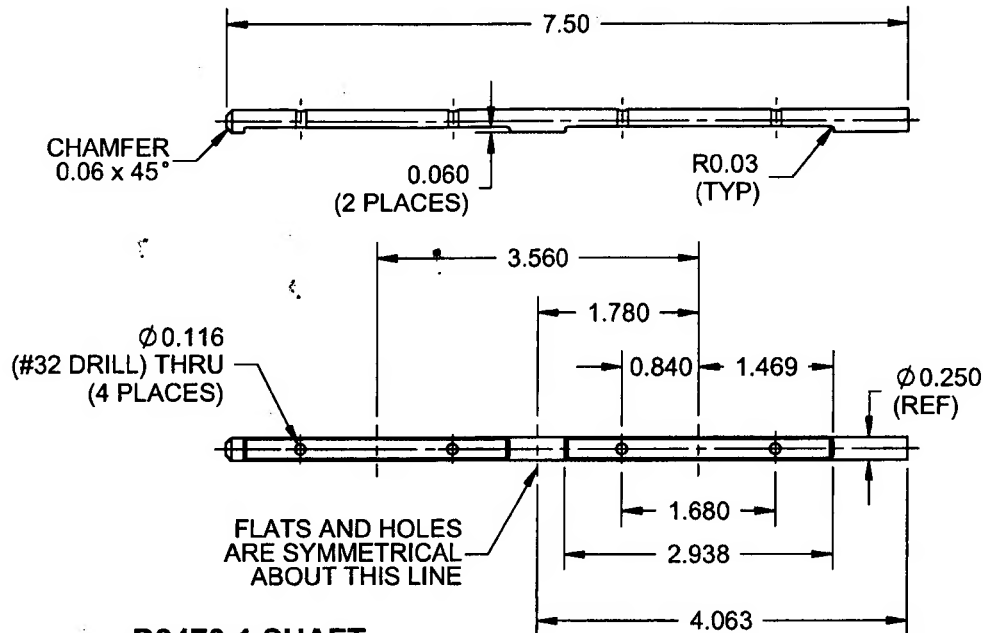
QTY -041	P/N	DESCRIPTION
X	D3470-041	SHUT-OFF VALVE SHAFT
1	D3470-1	SHAFT
1	D3470-3	CONTROL ARM

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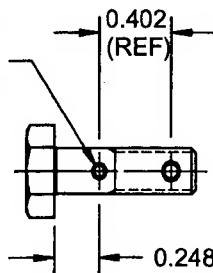
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DATE <b>05.12.14</b>		TITLE <b>SHUT-OFF VALVE SHAFT</b>	SCALE 1:2

**D3470-1 SHAFT**

- 1) MATERIAL: AISI 303 STAINLESS STEEL 0.25 ROUND BAR  
(REF. DART SPEC. M303R0.250)

Ø0.060 THRU AND  
C'SINK Ø0.09 x 100°  
ON BOTH SIDES

**D3470-9 BOLT**

SCALE 1:1

- 1) MAKE FROM AN4-6 BOLT

**NOTES:**

- 2) FINISH: NONE  
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES  
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

06-04-03  
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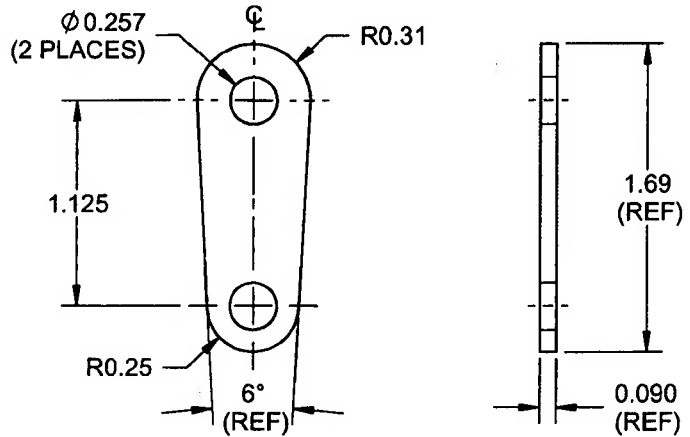
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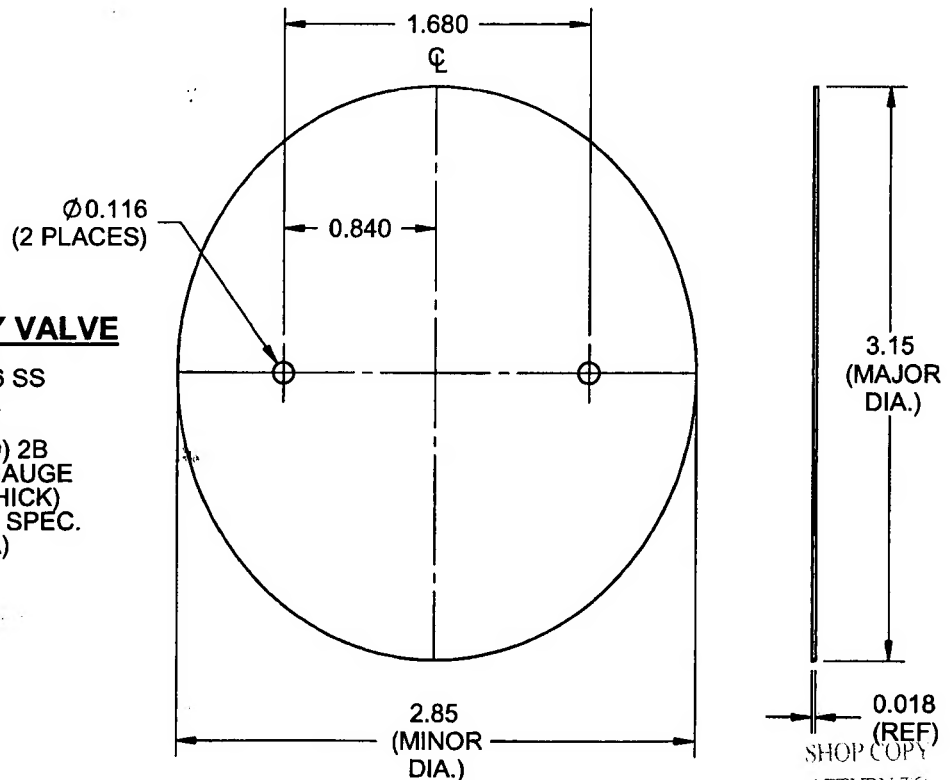
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3470</b>	REV. A SHEET 3 OF 4
DATE <b>05.12.14</b>		TITLE <b>SHUT-OFF VALVE SHAFT</b>	SCALE 1:1

**D3470-3 CONTROL ARM**

- 1) MATERIAL: AISI 304/316 SS SHEET PER  
MIL-S-5019 (ANNEALED) 2B  
FINISH 13 GAUGE SS  
(0.090 THICK)  
(REF. DART SPEC. M304S13GA)

**D3470-5 BUTTERFLY VALVE**

- 1) MATERIAL: AISI 304/316 SS  
SHEET PER  
MIL-S-5019  
(ANNEALED) 2B  
FINISH 26 GAUGE  
SS (0.018 THICK)  
(REF. DART SPEC.  
M304S26GA)

**NOTES:**

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

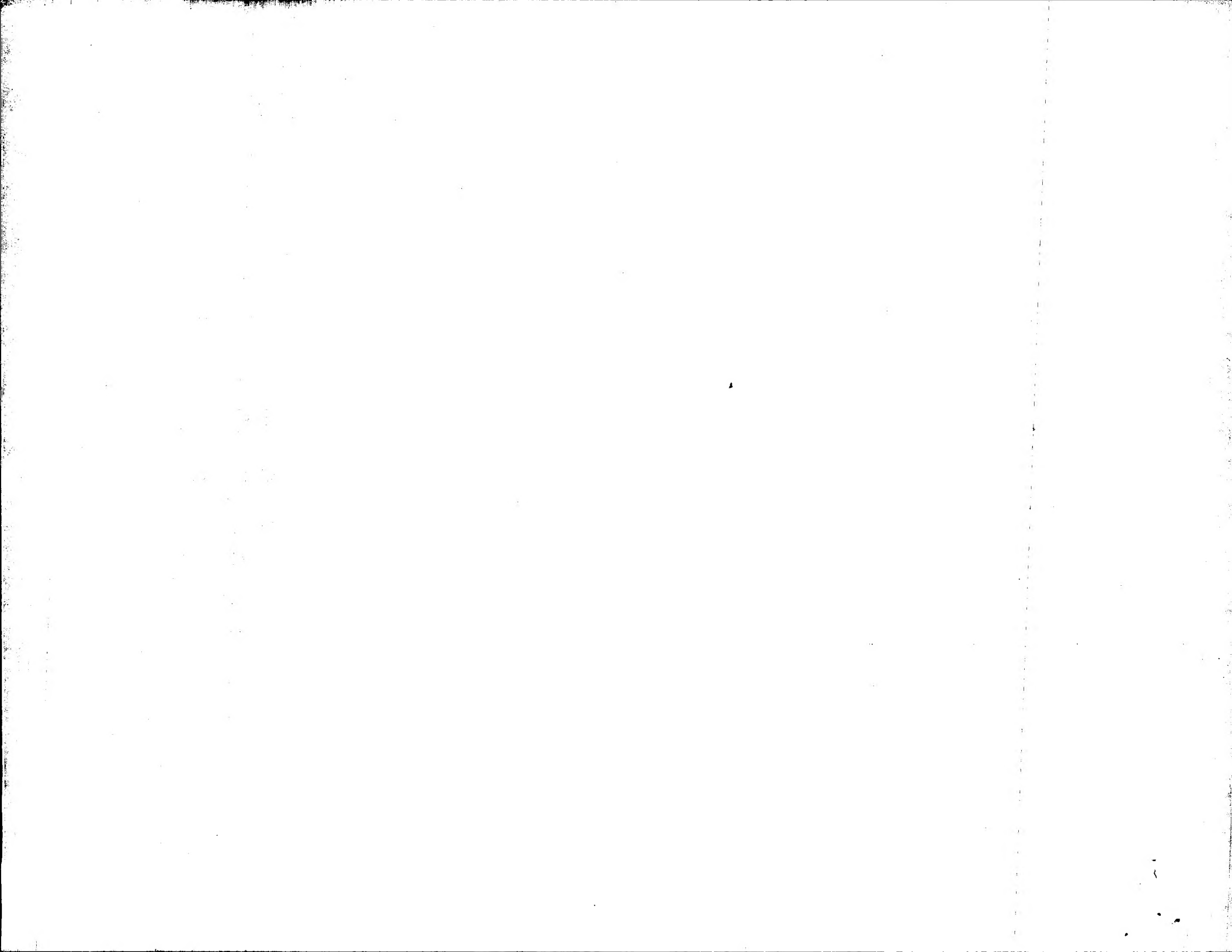
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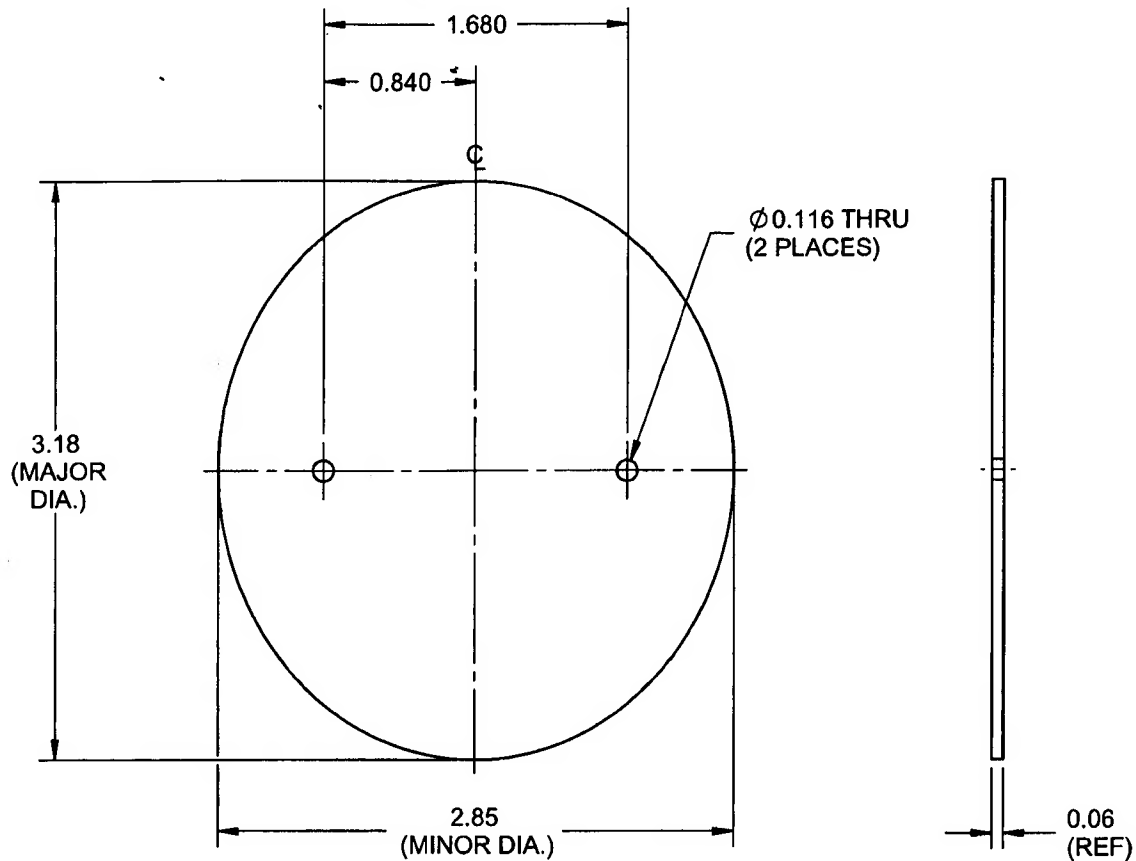
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DATE 05.12.14		TITLE SHUT-OFF VALVE SHAFT	SCALE 1:1

**D3470-7 BUTTERFLY VALVE SEAL****NOTES:**

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.063 THICK (REF. DART SPEC. M-SIL60-S.063)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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